

Work Order ID 66698 - 1

Thursday, February 24, 2011 9:45:37 AM

Page 1

Item ID: D2893-1

Accept

Setup Start

Revision ID:

Stop

Item Name: 2.75 Support

Start Date: 3/25/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-02-24

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA081 Tumble & Deburr

20

✓

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20

✓

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20

✓

SPLIT-1

split

mk 11/03/01

mk 11/02/03

mk 11.3.4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66698

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Page 2

Item ID: D2893-1

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Setup Start



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Item Name: 2.75 Support

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

M 11595L

Memo

0.00

Powder Coating

Mask Inside Bore for Priming START TIME: 0.45 OVEN TEMPERATURE 400 FINISH TIME: 9.15

20 BL 11-3-9

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

20 4 M-103/09

150



SprayPaint

Spray Painting

SprayPaint

0.00

Memo

0.00

Prime inside surface as per Dwg D2893 and QSI 005 4.3

M 11 03 21 ①

W/O:		WORK ORDER CHANGES					
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NOTE: Date & Initial all entries

Work Order ID 66698

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Page 3

Item ID: D2893-1

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Setup Start



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Start Date: 3/25/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

1 11-03-22

170

Identify as per dwg & Stock Location X-tubes

0.00



Packaging

Memo

0.00

Packaging

11 03 22 ①

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22 MF 11-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 24, 2011 9:45:45 AM

Page 1

Work Order ID: 66698

Parent Item: D2893-1

Parent Item Name: 2.75 Support



Start Date: 3/25/2011

Required Date: 3/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C 02.11.26 Reformat; Added P/O KJ
IPP D 06.04.19 removed alodine EC
IPP Rev:E Added priming as per Rev B 07-04-30 JLM
IPP F 08.03.19 Re-format EC verified by: DD
IPP Rev:G 08-05-15 add QC14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	20 0000	0.5	10			



D2893-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT

20

64897

10

66248

10

10 OK 11/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.998	2.997	2.998	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.051	.051	.050	.050	.051
AE	0.188	0.193		.189	.190	.190	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.154	.149	.148	.149	.149
AH	1.360	1.400		1.375	1.375	1.375	1.375	1.375
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.215	1.215	1.215	1.215	1.215
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: *cmf* Date: 11/03/02

Audited by: *ml* Date: 11.3.4

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.138	.138	.138	.141	.138
AG	0.140	0.160		.149	.150	.150	.149	.149
AH	1.360	1.400		1.370	1.370	1.370	1.370	1.371
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.210	1.210	1.210	1.212	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>Sur</i>	Date:	11/03/02
Audited by:	<i>ml</i>	Date:	11.3.02
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>ml</i>

DART AEROSPACE LTD		Work Order:	66698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.998	2.998	2.999	2.999	2.999
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.130	.130	.131	.130
AD	0.040	0.060		.057	.050	.050	.049	.050
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.150	.150	.152	.150	.147
AH	1.360	1.400		1.372	1.371	1.372	1.376	1.371
AI	0.040	0.060		.050	.050	.048	.049	.045
AJ	1.190	1.230		1.210	1.210	1.211	1.215	1.212
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>amk</i>	Date:	11/03/03
Audited by:	<i>ml</i>	Date:	11-3-4
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	66698
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

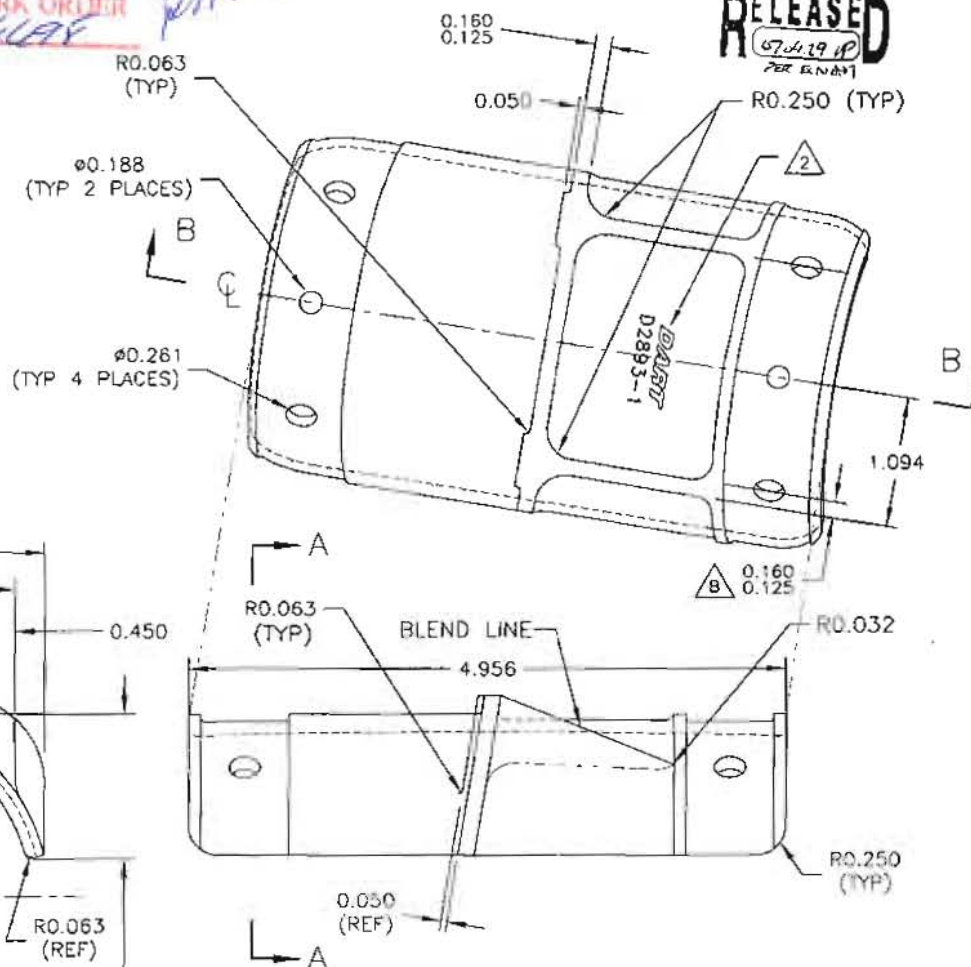
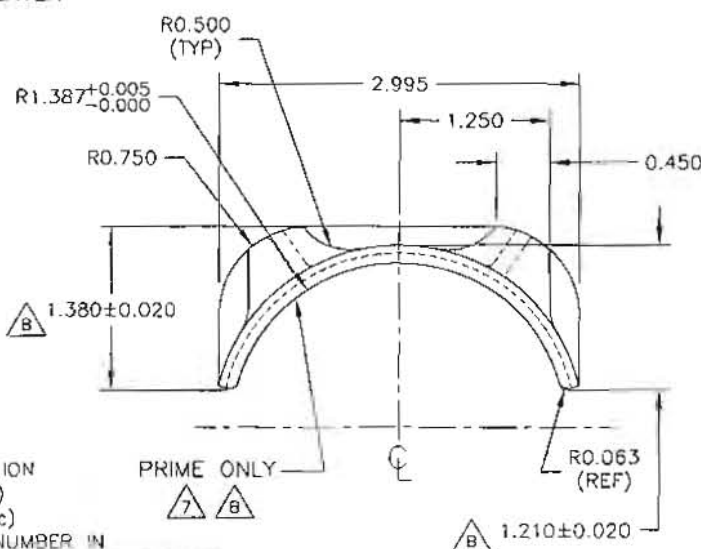
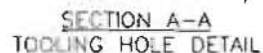
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005	Vein ML-7	2.999	2.999	2.998	2.998	2.998
AB	0.440	0.460	"	.440	.440	.446	.440	.440
AC	0.125	0.160	"	.136	.132	.136	.130	.130
AD	0.040	0.060	"	.050	.049	.050	.050	.050
AE	0.188	0.193	"	.191	.191	.191	.191	.191
AF	0.125	0.160	"	.141	.139	.140	.140	.141
AG	0.140	0.160	"	.150	.152	.150	.151	.153
AH	1.360	1.400	High-gage 31006	1.376	1.376	1.374	1.371	1.373
AI	0.040	0.060	Test-indicator	.048	.048	.049	.049	.046
AJ	1.190	1.230	High-gage 31006	1.213	1.215	1.213	1.211	1.212
AK	0.010	0.020	Test-indicator	.010	.010	.010	.010	.010
AL	0.053	0.073	Rad-gage	.063	.063	.063	.063	.063
AM	0.240	0.260	"	.250	.250	.250	.250	.250
AN	2.518	2.538	Vein ML-7	2.528	2.525	2.528	2.528	2.528
AO	84.39	90.39	-	87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266	Vein ML-7	.262	.262	.262	.262	.262
AQ	0.053	0.073	Rad-gage	.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								



Measured by:	<i>CanL</i>	Date:	11/03/03
Audited by:	<i>ml</i>	Date:	11-3-4
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>JA</i>

WITHOUT NOTICE
WORK ORDER
NO. 6496

RELEASE
67-429-1P



1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc) PRIME ONLY
 

2) IDENTIFY WITH PART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP

3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
GALT WEAVER INC.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE		TITLE	
07.03.16		02.750 SUPPORT	


DART AEROSPACE LTD.
 MARKHAM, ONTARIO, CANADA

REV. _____
 SHEET 1 OF _____
 SCALE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries